

Work Order ID 82587

82587

Page 1

April-03-12 10:35:54 AM

Item ID: D3208-3 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Mount Angle
 Start Date: 03/04/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3208	Rev B

100	FLOW WATER JET	0.00				6	0		JM
100									
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3208 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-								
	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00				6	0		JM
110									
QC									
Quality Control	Memo	0.00							

120	QC8- Inspect parts - second check	0.00							
120									
QC									
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82587

82587

Page 2

April-03-12 10:35:54 AM

Item ID: D3208-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Mount Angle

Start Date: 03/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

0.00

Memo

Deburr D3208-3 Form D3208-3 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208

6

SB 14/05/31

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

5/7/31

6

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

6 14/12/6.4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 82587

April-03-12 10:35:54 AM

82587

Page 3

Item ID: D3208-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Mount Angle

Start Date: 03/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x 6 MU 1402/06

170

Identify as per dwg & Stock Location: 51202 0.00

170

Packaging

Memo

0.00

Packaging

6 542 12/06/05

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/06/15 JH
MR
12-06-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-03-12 10:35:58 AM

Page 1

Work Order ID: 82587

82587

Parent Item: D3208-3

D3208-3

Parent Item Name: Pedal Mount Angle

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B04.05.25Material changed for Step 4KJ/JLM

IPP Rev:C Now on Waterjet 06-10-12 JLM

D:PER REV B 12-03-23 JLM VERIFIED BY:EC

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	311.9196	0.0659	0.416211			

M6061T6S 063

**

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

311.9195684

113608

0

116308

6.51556842

117285

70.544

119331

47

119802

20.94

120218

26

120866

140.92

121805

121805

JM
12-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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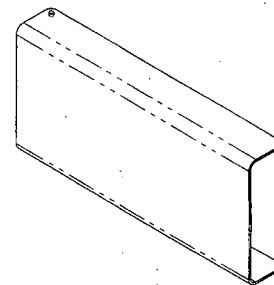
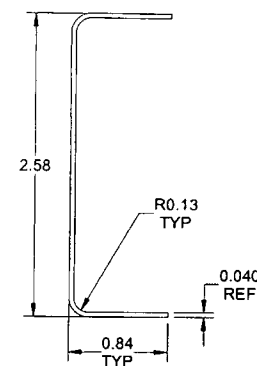
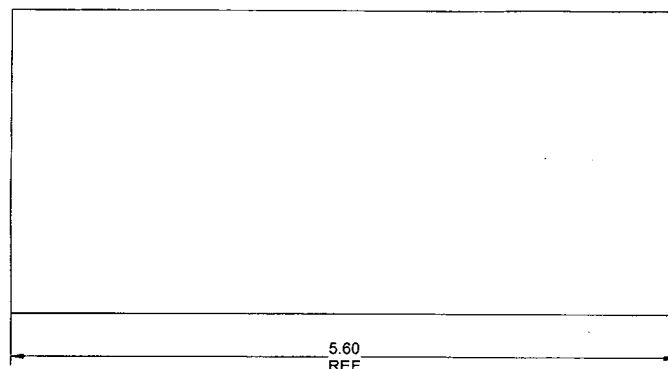
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 87587 MW
12/04/03

RELEASED
2012-03-21
EN 12-545

D3208-1 DOUBLER

NOTES:

- 1) MATERIAL: MAKE FROM D3208-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

B	CONVERT DRAWING TO STANDARD FORMAT; RE-DESIGN D3208-1 (ZN B5-1, B5-2); RE-DESIGN D3208-7 (B5-7); CHANGE TO 2 DEG. PLACES (ZN B5-4, C7-4, C3-8, B4-8, C6-8, D5-8, C6-8, B5-8; ADD HOLE TO D3208-9 ZN (B4-8); 1.50 WAS 1.250 (ZN C4-9) PER PAR12-162	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 1 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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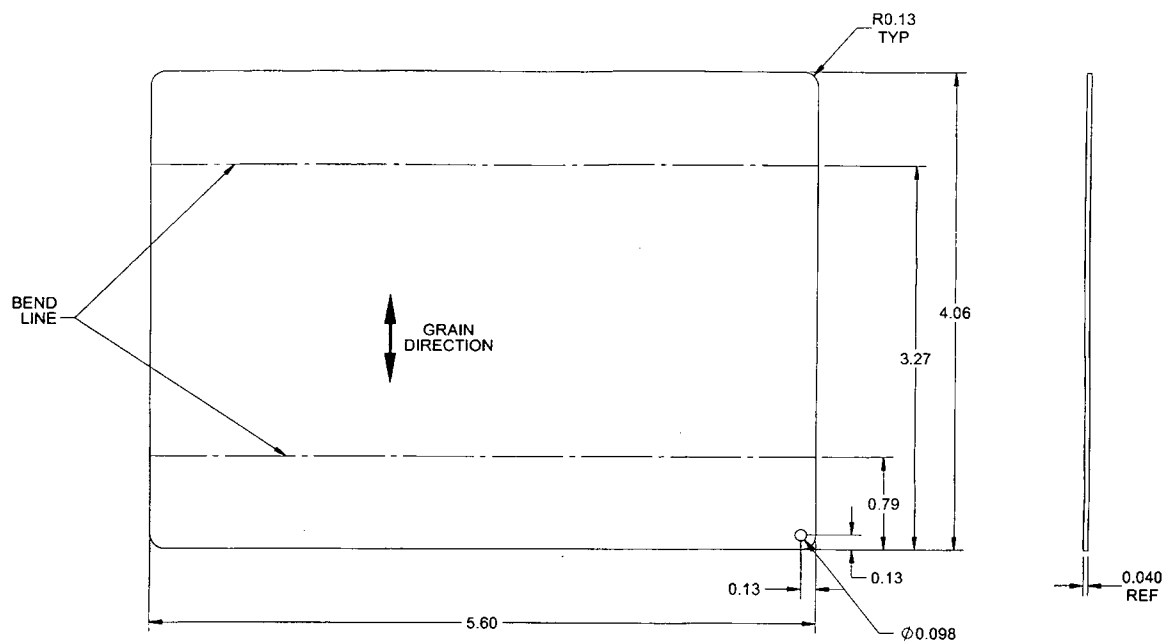
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3208-1F DOUBLER FLAT PATTERN

RELEASED
2012-03-21
UP

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

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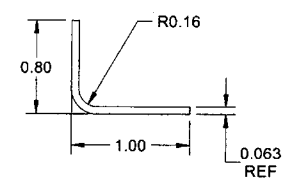
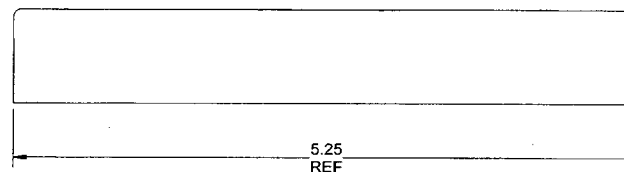
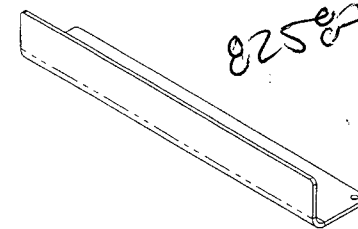
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3208-3 PEDAL MOUNT ANGLE

RELEASED
2012-03-21
CP

NOTES:

- 1) MATERIAL: MAKE FROM D3208-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

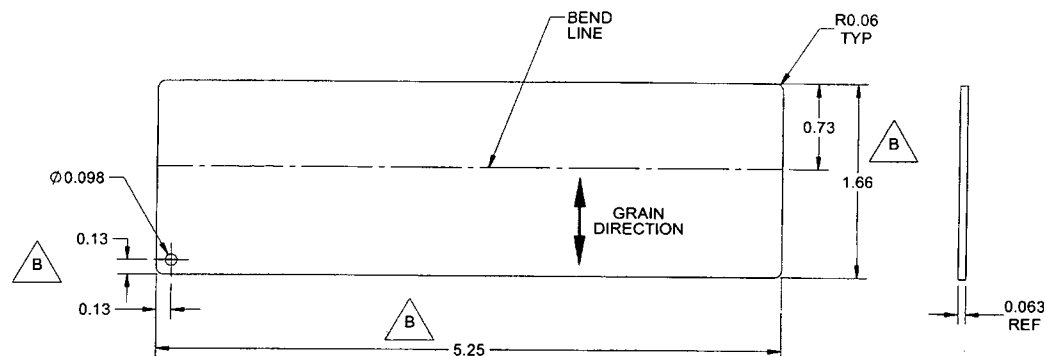
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3208-3F PEDAL MOUNT ANGLE FLAT PATTERN

RELEASED
2012-03-21

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

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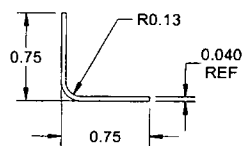
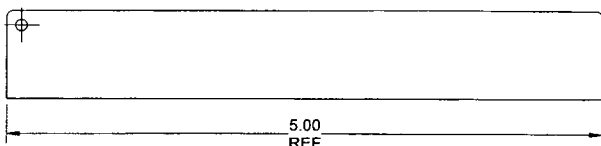
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

02587

D3208-5 MOUNT ANGLE

RELEASED
2012-03-21
AP

- NOTES:**
- 1) MATERIAL: MAKE FROM D3208-5F FLAT PATTERN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 5 OF 9
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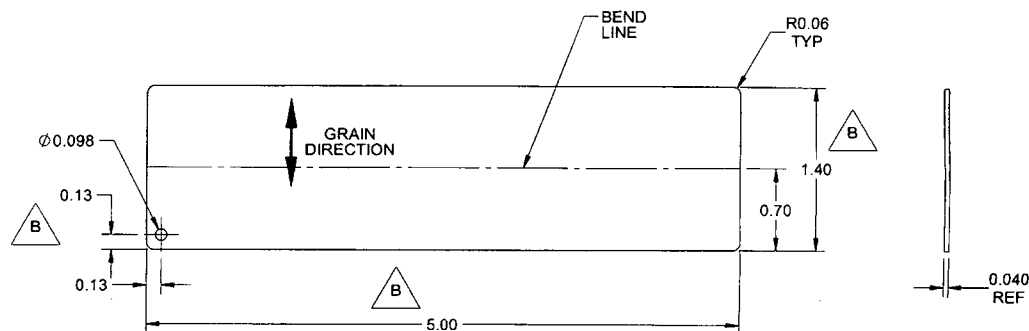
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NOTE: Date & initial all entries

82587



D3208-5F MOUNT ANGLE FLAT PATTERN

RELEASED
2012-03-21
up

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

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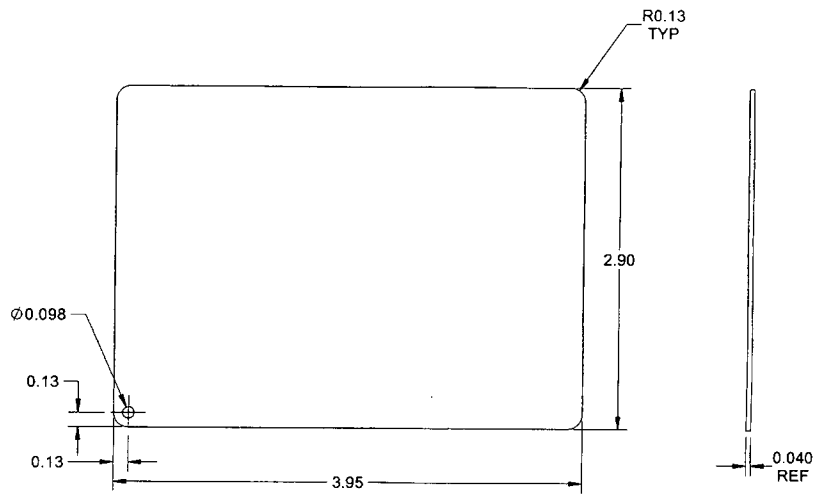
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NOTE: Date & initial all entries

82587



B **D3208-7 FILLER**

RELEASED
2012-03-21
CP

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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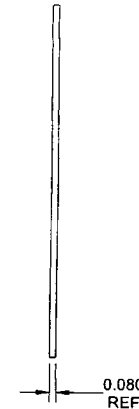
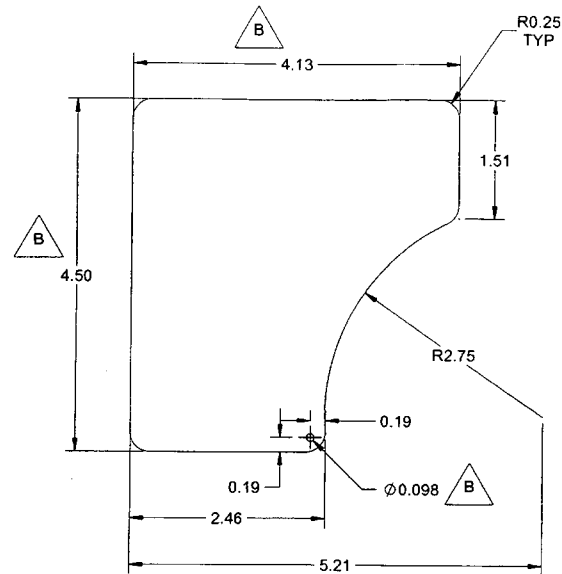
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

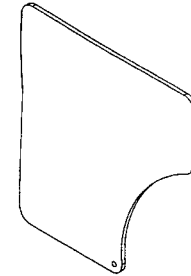
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82587



D3208-9 DOUBLER

RELEASED
2012-03-21

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
DATE	12.02.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

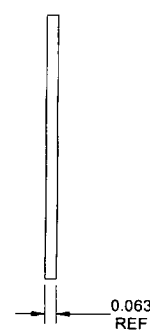
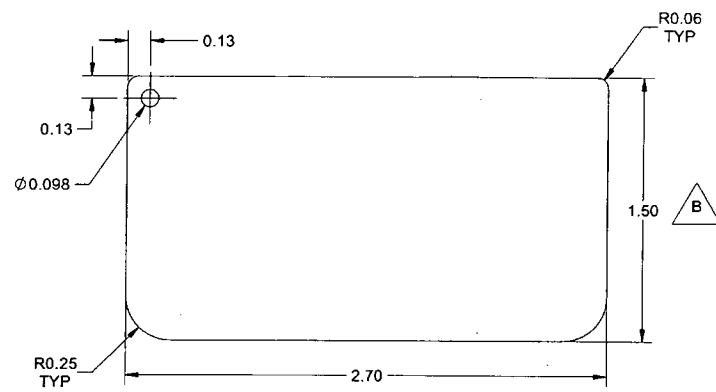
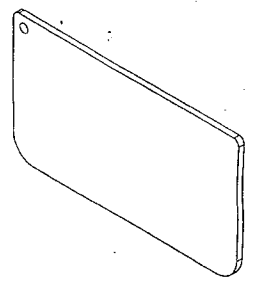
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82587



D3208-11 FILLER

RELEASED
2012-03-21

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3208	SHEET 9 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOUBLER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries